

Work Order ID 63005

October 15, 2010 10:37:11 AM



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Item ID:	D2423	Accept		Setup	Start	
Revision ID:						
Item Name:	Lug Extrusion				Stop	
Start Date:	10/15/10	Start Qty:	36.00	Cust Item ID:		
Required Date:	11/12/10	Req'd Qty:	36.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/10/15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D2423	Rev B1								

100
 PURCHASING 0.00
 Purchasing Memo 0.00
 Purchasing Issue P/O: 12748
 Manufacture as per Dwg
 Possible Supplier: SIGNATURE ALUMINUM
 Material release note is required

CZ 10/10/15 288

110
 Receive & Inspect for Damage & Mat'l Certs 0.00
 Packaging Memo 0.00
 Packaging

10/11/10 (36) 288

120
 QC6- Inspect dimensions to drawing 0.00
 QC Memo 0.00
 Quality Control

5 10/11/12

(36) 288

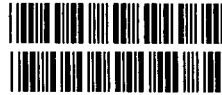
* Pulver to dry x 10 length
 and check thoroughly to day.

Picklist Print

October 15, 2010 10:37:18 AM

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Work Order ID: 63005



Parent Item: D2423

Parent Item Name: Lug Extrusion

Start Date: 10/15/10

Required Date: 11/12/10

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP ☐ G ☐ 04.09.02 ☐ Part Number D2423-108 changed to D2423 ☐ KJ/JLM ☐

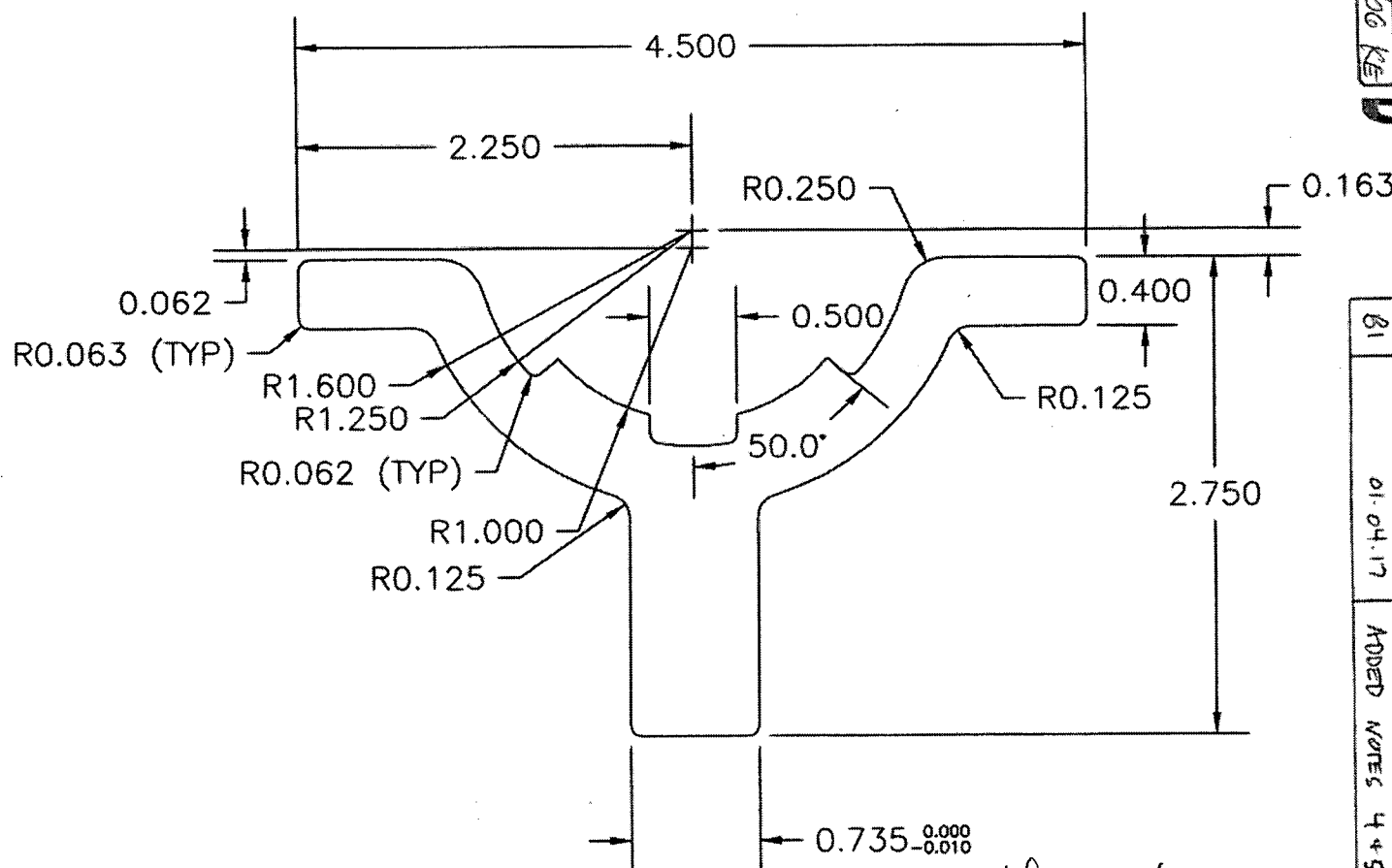
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423P Lug Extrusion		Purchased	No			100	f	0.0000	1	26 288.67		10/15/10	(36/288)

DART



RELEASED
98/08/06 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
98.08.04		95.05.09		LUG EXTRUSION	
A		98.08.04		NEW ISSUE	
B		01.04.17		6061-T6 WAS 6005A.T5	
B1		ADDED NOTES 4+5		SHEET 1 OF 1	
				SCALE	
				1:1	



CL10110115
W10.63005

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALOX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO12748

Purchase Order Date 10/15/10
PO Print Date 10/15/10

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name
Vendor Phone 800 563 1079
Vendor Fax 800 565 8339
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
10/15/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2423P	Lug Extrusion	11/12/10 Yes	288.00 f	Yours ppd	\$10.2500	\$2,952.00

Special Inst: EXTRUDE AS PER DWG D2423
REV.B
MATERIAL: 6061-T6 AS PER QQ-A-
200/8
SIGNATURE ALUMINUM DIE #
DAA-5
CUT AT 8FT LENGTH
36 PCS = 10 288 FT

PO Total: \$2,952.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 10/15/10



ACCT# 00046024

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE
11-09-10
MANIFEST NUMBER
685383
SALES ORDER NUMBER
66488REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCECREDIT REP
DHILLON, ROBE

SALES REP

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNSOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNTERMS / FREIGHT
O / P

PHONE 613-632-5200

PHONE 613-632-5200

LOCATION TRAILER NUMBER SALESMAN
PIC JODEE 62554FIELD SALES REP
Bates M
905-427-2235CUST SERVICE REP
Burton D
905-427-2227CUSTOMER ID ORDER DATE CUSTOMER PO NUMBER
46024 10/15/10 12748

JOB

BILL OF LADING NUMBER
08411772

CUSTOMER ID 46024		ORDER DATE 10/15/10		CUSTOMER PO NUMBER 12748		MFG. PART NUMBER		ALLOY & TEMPER		FINISH DESCRIPTION		THIS SHIPMENT			UNIT		QUANTITY DUE	
ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	CUSTOMER PART NUMBER		LENGTH		FABRICATION DESCRIPTION		NBR OF PKGS	GROSS POUNDS	NET QUANTITY		UNIT	QUANTITY DUE			
						CUTTING TOLERANCE		SHIPPING TOLERANCE										
01	1109	LB	0	DAA-5-2		6061 /T6		MILL		1	1098	1080		LB	0			
	288	FT	0	D2423P		8'		CERTIFICATE OF COMP				288.00		FT	0			
	36	PC	0			+3/16 "		(+015-015,0041-0030)				36		PC	0			
						-0 "												
				LOT/TKT DETAIL:				66488010 / 376836		1	1098	1080			36 PC			

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

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DATE OF DELIVERY

DRIVER



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
11/09/10	211137	66488	1
Cust PO	B/I No	Lot	Date
12748	08411772	66488010	11/11/10

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON

Item No	Part No	Item Description	Cust Part
1.000	DAA-5-2	8' MILL 6061 T6	D2423P
Gross Weight	1098 LBS		
Net Qty	1,080 LB	36 PC	288 FT 1 PKG
Specification	Die Desc		
AMS QQA 200/B + ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	318.7 / 46.3	292.3 / 42.4	20.8	.0	91

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.67	.26	.29	.05	.92	.06	.10	.02

8
10/14/12

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Ryan Petersen, QA Manager Signature Aluminum Canada Inc